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D4503-1
Job Sheet 187094



Part No: D4503-1

Job Qty: 2 ea

Part Name: Upper Door Skin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP REV:A 11.12.28 new issue DD verf:EC IPP REV:B 12.10.10 AS PER DWG REV.B DD
VERF:JLM IPP REV:D 14.03.27 PER DWG REV.C DD VERF:JLM IPP REV:E 15.08.27 PER DWG REV.D DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		1/31/19	0.00	0.61	Waterjet - Flow		JE 18/12/10
110	QC	2 pcs		1/31/19	0.00	0.00	QC2 Waterjet-3		JE 18/12/10 DAS
120	QC	2 pcs		1/31/19	0.00	0.00	QC8-5		DEC 29 2018 68
130	HandFinish	2 pcs		1/31/19	0.00	0.55	HandFinish1		D.R 18/12/31-89
140	QC	2 pcs		1/31/19	0.00	0.00	QC7-4		AS 19-1-8
150	SprayPaint	2 pcs		1/31/19	0.00	0.62	Spray Paint		AS 19-1-8
160	QC	2 pcs		1/31/19	0.00	0.00	QC14		38
170	Packaging	2 pcs		1/31/19	0.00	0.00	Packaging3-2	51368	JAN 10 2019
180	QC21-SA	2 Ea		1/31/19	0.00	0.00	QC21		21 JAN 10 2019

Part Op 100 - 1-Cut as per Dwg Dwg Rev: D Prog Rev: D 2-Debur if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Chemical Conversion Coat per QSI005 4.1
140 - QC7-Inspect Chemical Conversion Coat
150 - Prime tempo grey as per dwg (note 2) Batch: 5135773
160 - QC14- Inspect Spray Paint
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	16.8000 sf (8.4 ea)	100-Waterjet - Flow - 1	M138173

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.032	17	128	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														



Container No: S136458



Part: D4503-1

Job No: 187094

Serial No/Batch: S136458

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/08/19